

# Work Order ID 64827

Friday, December 17, 2010 8:05:01 AM



Page 1

Item ID: D3208-1

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 12/16/2010 Start Qty: ~~6.00~~

Cust Item ID:

Required Date: 1/19/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

*PL*

Date: 10-12-17 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3208	Rev A1								
100		0.00							
	SHEAR								
Shear	Memo	0.00							
Shear	Cut blank: 4.038" X 5.340" grain along 4.038" Identify for D3208-1								
									<i>=&gt; m.d 11/01/10</i>
110		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Drill and Fillet D3208-1 corner as per Dwg D3208 Identify as D3208-1								
									<i>=&gt; m.d 11/01/10</i>
120		0.00							
	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	Deburr D3208-1 Form D3208-1 as per Dwg D3208 Polish any marks on part within 01. of Dwg D3208								
									<i>B 11/01/10</i>

*(8x)*

*(8x)*

*(8)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 64827**

Friday, December 17, 2010 8:05:01 AM

Page 2

Item ID: D3208-1

Accept

Revision ID:

Item Name: Doubler

Start Date: 12/16/2010 Start Qty: 6.00

Required Date: 1/19/2011 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sutulu

28

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

=7

8 0 21 11/17/11

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8 11-01-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

**Work Order ID 64827**

Friday, December 17, 2010 8:05:01 AM

Page 3

Item ID: D3208-1

Accept

Revision ID:

Item Name: Doubler

Start Date: 12/16/2010 Start Qty: 6.00

Required Date: 1/19/2011 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Identify as per dwg & Stock Location: 202

0.00



Packaging

Memo

0.00

Packaging

11/11/11 SP (82)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/12 JF

CMF

11-01-11

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, December 17, 2010 8:05:05 AM

Page 1

Work Order ID: 64827

Parent Item: D3208-1

Parent Item Name: Doubler



Start Date: 12/16/2010

Required Date: 1/19/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B04.05.25 Material changed for Step 4 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	219.9400	0.1645	1.038947			
2024-T3 .040 sheet													

Location	Loc Qty	Loc Code
MAT	30.2	
114415	30.2	
MAT22	189.74	
110305	21.93	
111786	9.66	
112291	28.25	
112331	52	
113162 ✓	77.9	

M-L 11/01/10

\*

~~1.038947~~ 1.4805

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

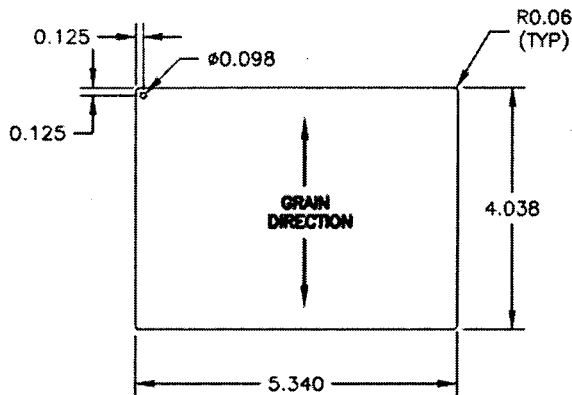
**NOTE:** Date & initial all entries



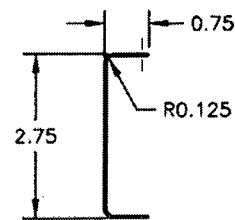
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DATE 04.01.27		TITLE DOUBLER	SCALE 1:3
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AI	<del>#</del> 04.05.25	CHANGE DIM, NOTE 3) CHANGE	

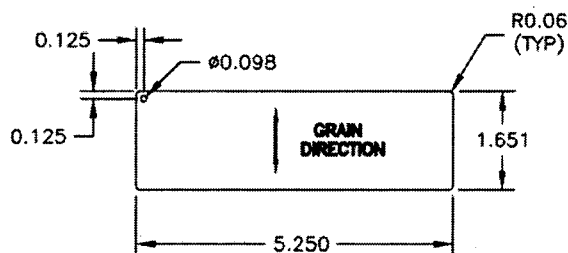
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04.04.05 *#*



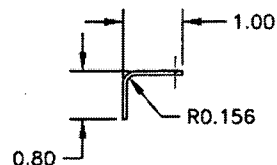
2 D3208-1 DOUBLER  
FLAT PATTERN



D3208-1 DOUBLER  
BEND DETAIL



3 D3208-3 PEDAL MOUNT ANGLE  
FLAT PATTERN



D3208-3 PEDAL MOUNT ANGLE  
BEND DETAIL

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *04827*

*2/10-12-17*

NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040" THICK (M2024T3S.040)
- 3) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063" THICK (M2024T3S.063)
- 4) MATERIAL: 2024-T3 (QQ-A-250/4) 0.080" THICK (M2024T3S.080)
- 5) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

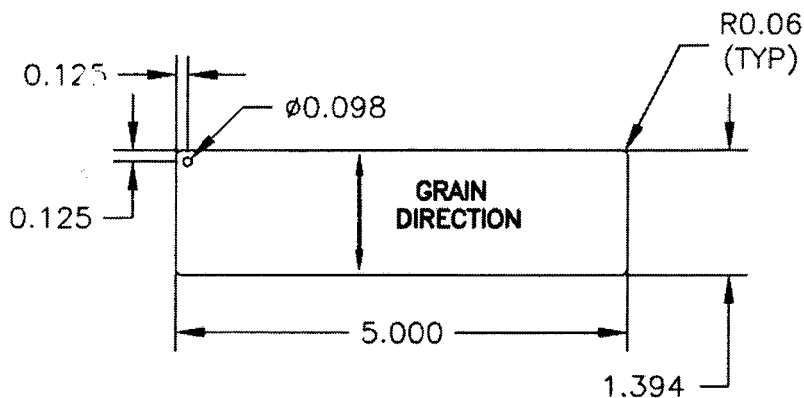
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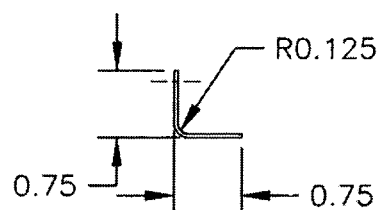


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CHECKED H	APPROVED H	DRAWING NO. D3208	REV. A SHEET 2 OF 3
DATE 04.01.27		TITLE DOUBLER	SCALE 1:2

RELEASED  
04.04.05 H

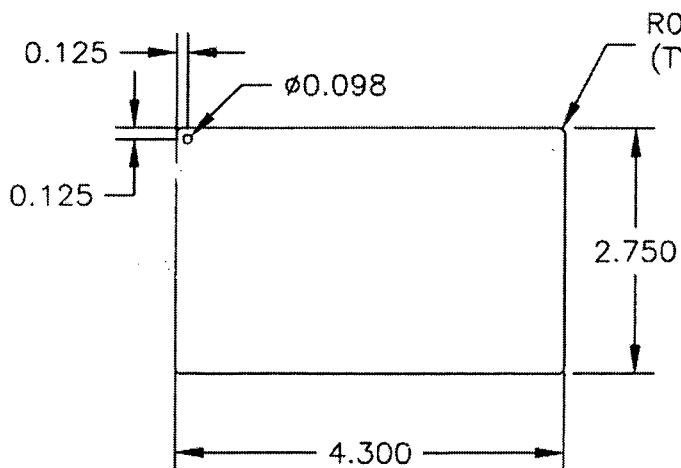


2 D3208-5 MOUNT ANGLE  
FLAT PATTERN

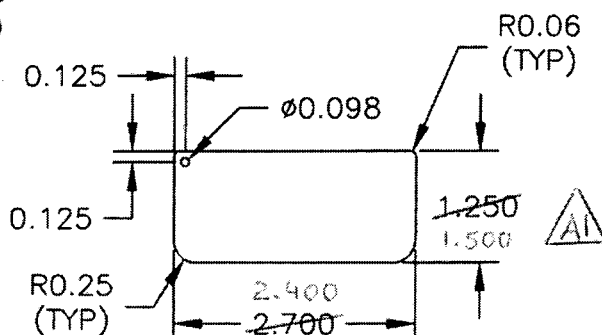


D3208-5 MOUNT ANGLE  
BEND DETAIL

w/o 64827



2 D3208-7 FILLER



2 D3208-11 FILLER

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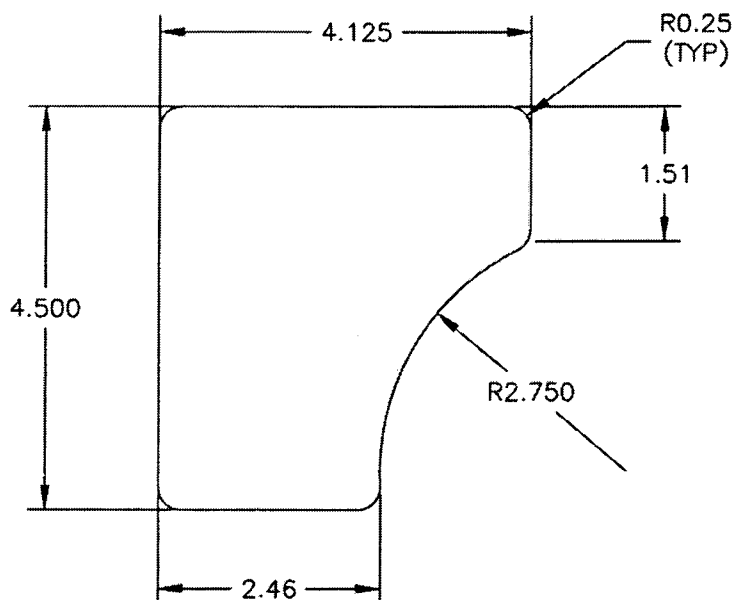
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3208	REV. A SHEET 3 OF 3
DATE 04.01.27		TITLE DOUBLER	SCALE 1:2

RELEASED  
04.04.08 [Signature]



u/o 64827



**D3208-9 DOUBLER**

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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